

Date: Thursday, 02/04/2009 2:28:06 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : INTERIOR TRIM KIT (AFT BULKHEAD TRIM KIT)
 Job Number : 46874
 Estimate Number : 13260
 P.O. Number :
 This Issue : 02/04/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D350766011
 First Issue : // Type : THERMOFORMING Drawing Number : IIN350-766 REV A
 Previous Run : 46873 Drawing Revision : A
 Written By : Due Date : 17/04/2009 Qty: 1 Um: Each
 Checked & Approved By : JUD 09.04.03
 Comment : Est REV A NEW ISSUE 08/04/08 DL verified by:DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D350-766-011 CHG001x2

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D36551 PANEL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PANEL

batch: 47073

4.0 D36553 PANEL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PANEL

batch: 47020

5.0 MS21059L3 Nut Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut Plate

batch: M107394

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Description :

6.0

CCR274SS34

Cherry Rivet



J Comment: Qty.: 8.0000 (s)/Unit Total : 8.0000 (s)
Cherry Rivet
batch: M107438

SS 09/04/15 (X)

7.0

AN5261032R12

Screw



J Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Screw
batch: M1568

SS 09/04/15 (X)

8.0

AN5261032R20

Screw



J Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Screw
batch: M10216

SS 09/04/15 (X)

9.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 09/04/15 (X)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350766-011

Location: B

PPP Rev: 09/04/20

SS 09/04/20 (X)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SS 09/04/20 (X)

Job Completion



U 09.04.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

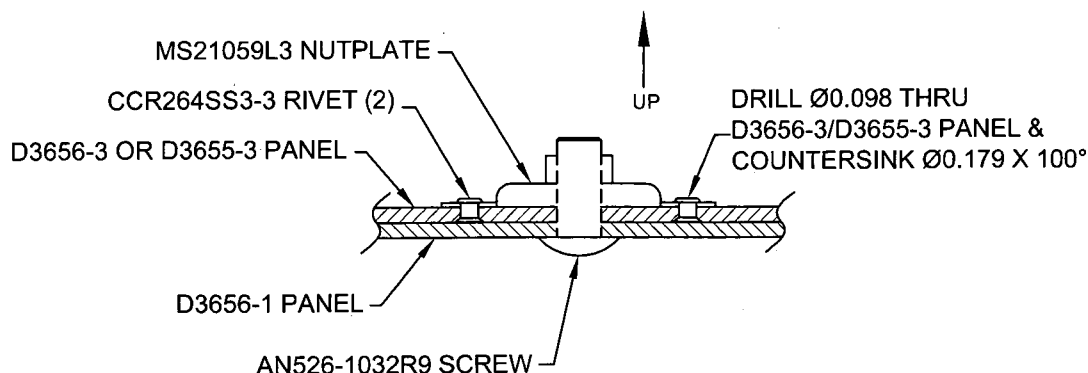


Figure 6 – Nutplate Installation

4.0 WEIGHT AND BALANCE

The following is the weight increase associated with the Interior Trim Kits. Be sure to subtract the weight of any parts removed.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-766-011 Interior Trim Kit (Aft Bulkhead Trim Kit)	13.2 lb 6.0 kg	0 in 0 m	0 in-lb 0 m-kg	113 in 2.87 m	1492 in-lb 17.2 m-kg
D350-766-013 Interior Trim Kit (Ceiling Trim Kit)	11.0 lb 5.0 kg	0 in 0 m	0 in-lb 0 m-kg	91 in 2.31 m	1001 in-lb 11.6 m-kg

5.0 PARTS LIST

Qty -011	Qty -013	Part Number	Description
X		D350-766-011	INTERIOR TRIM KIT (AFT BULKHEAD TRIM KIT)
	X	D350-766-013	INTERIOR TRIM KIT (CEILING TRIM KIT)
1		D3655-1	PANEL
1		D3655-3	PANEL
	1	D3656-1	PANEL
	1	D3656-3	PANEL
4	15	MS21059L3	NUTPLATE
	30	CCR264SS3-3	RIVET
8		CCR274SS3-4	RIVET
	15	AN526-1032R9	SCREW
2		AN526-1032R12	SCREW
2		AN526-1032R20	SCREW

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WORK ORDER

NO. 46874

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Revision: **A**
Date: 08.03.03

Date: Wednesday, 08/04/2009 11:53:02 AM
User: Julie Dawson

Process Sheet

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Prsht Rev. : NC Project Number :
First Issue : 02/04/2009 Type : THERMOFORMING Drawing Revision : A
Previous Run : 46873 Material :
Written By : Due Date : 17/04/2009 Qty: 1 Um: Each
Checked & Approved By :
Comment : Est REV A NEW ISSUE 08/04/08 DL verified by:DD

Additional Product

REFERENCE ONLY

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JPD 09.04.15



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D350-766-011 CHG001

/ 802/04/15

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

Job Completion

